

Work Order ID 60249

Page 1

Tuesday, June 29, 2010 3:48:32 PM

Item ID: D3813-043

Accept



Setup Start



Revision ID:

Item Name: Hinge Assembly, Lower Door

Stop



Start Date: 6/29/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 06-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3813	Rev A								
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100		0.00							
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	Small Fab								
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Small Fab	Memo	0.00							
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Small Fab	1-Install helicoils as per Dwg D3813 2-Install Ball joint and nut loosely as per Dwg D3813							
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(UR) 7M-1 10/07/14

110	QC5- Inspect part completeness to step on W/O	0.00							
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	Memo	0.00							
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QC									
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Quality Control									
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S.0(07/14)

(X8)

120	Identify as per dwg & Stock Location: 089	0.00							
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	Memo	0.00							
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Packaging									
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Packaging									
-----------	--	--	--	--	--	--	--	--	--

L3 14/17 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 6/29/2010 Start Qty: 4.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10-7-14

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Picklist Print

Page 1 /1

Tuesday, June 29, 2010 3:48:36 PM

Work Order ID: 60249



Parent Item: D3813-043



Parent Item Name: Hinge Assembly, Lower Door

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3518-3 		Manufactured	No			100	Each	14.0000	1	4			
Stainless Steel Ball Joint Rod End												10/07/14	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST067	14					
							39029	6					
							53454	8					
D3813-3 		Manufactured	No			100	Each	6.0000	1	4			
Hinge, Lower Door												10/07/14	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST090	6					
							42053	1					
							53045	5					
MS124738 		Purchased	No			100	Each	45.0000	1	4			
Heli-Coil 3/8-24 unf												10/07/14	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST314	45					
							113368	45					
NAS509-6 		Purchased	No			100	Each	20.0000	1	4			
Nut												10/07/14	
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST280	20					
							113537	20					

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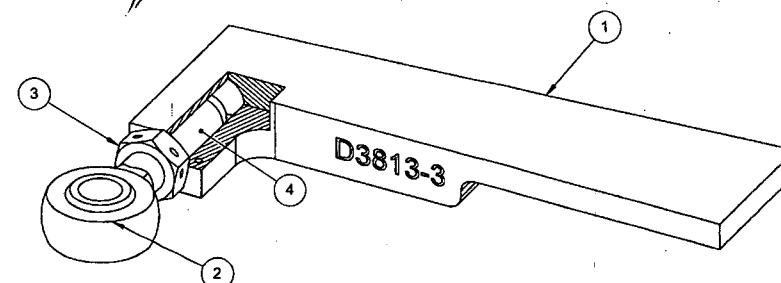
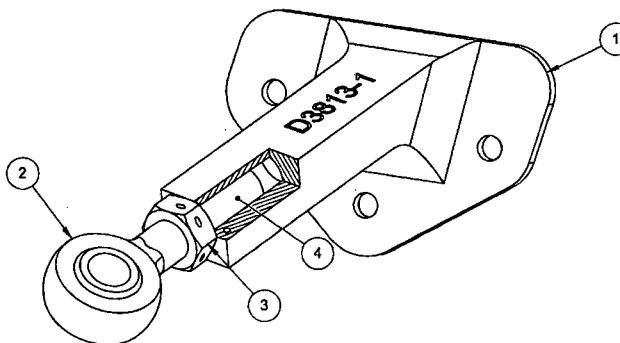
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO.

60249
B10629



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-043 HINGE ASSY, LOWER DOOR

RELEASED
07/01/13 MJP

A	NEW ISSUE	08.11.10
REV.	DESCRIPTION	BY DATE
DESIGN	<i>[Signature]</i>	
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	SHEET 1 OF 4
DE APPR.	<i>[Signature]</i>	TITLE
DATE	08.11.10	SCALE
		HINGE
		NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3813

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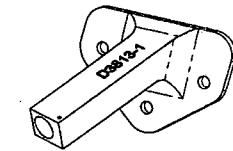
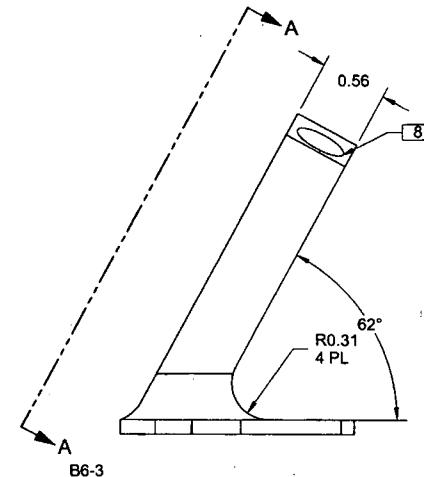
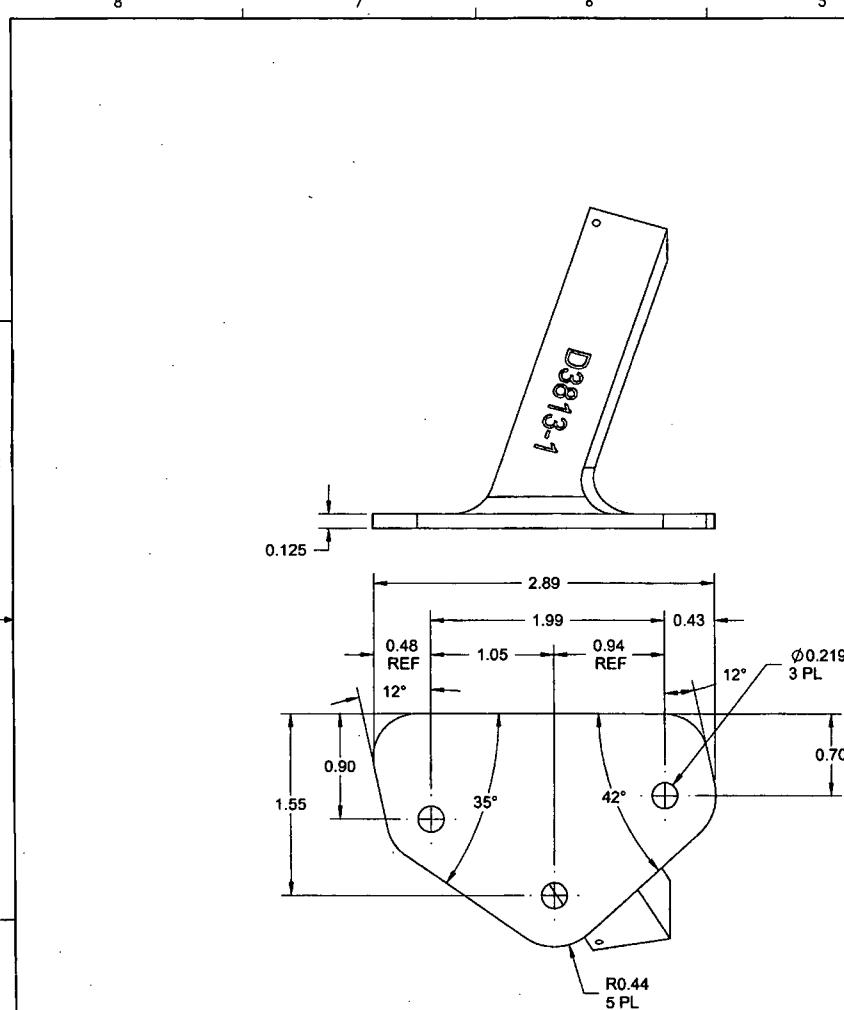
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Wb 602119

D3813-1 HINGE, UPPER DOOR

NOTES:

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.14 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD		
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CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3813	SHEET 2 OF 4	
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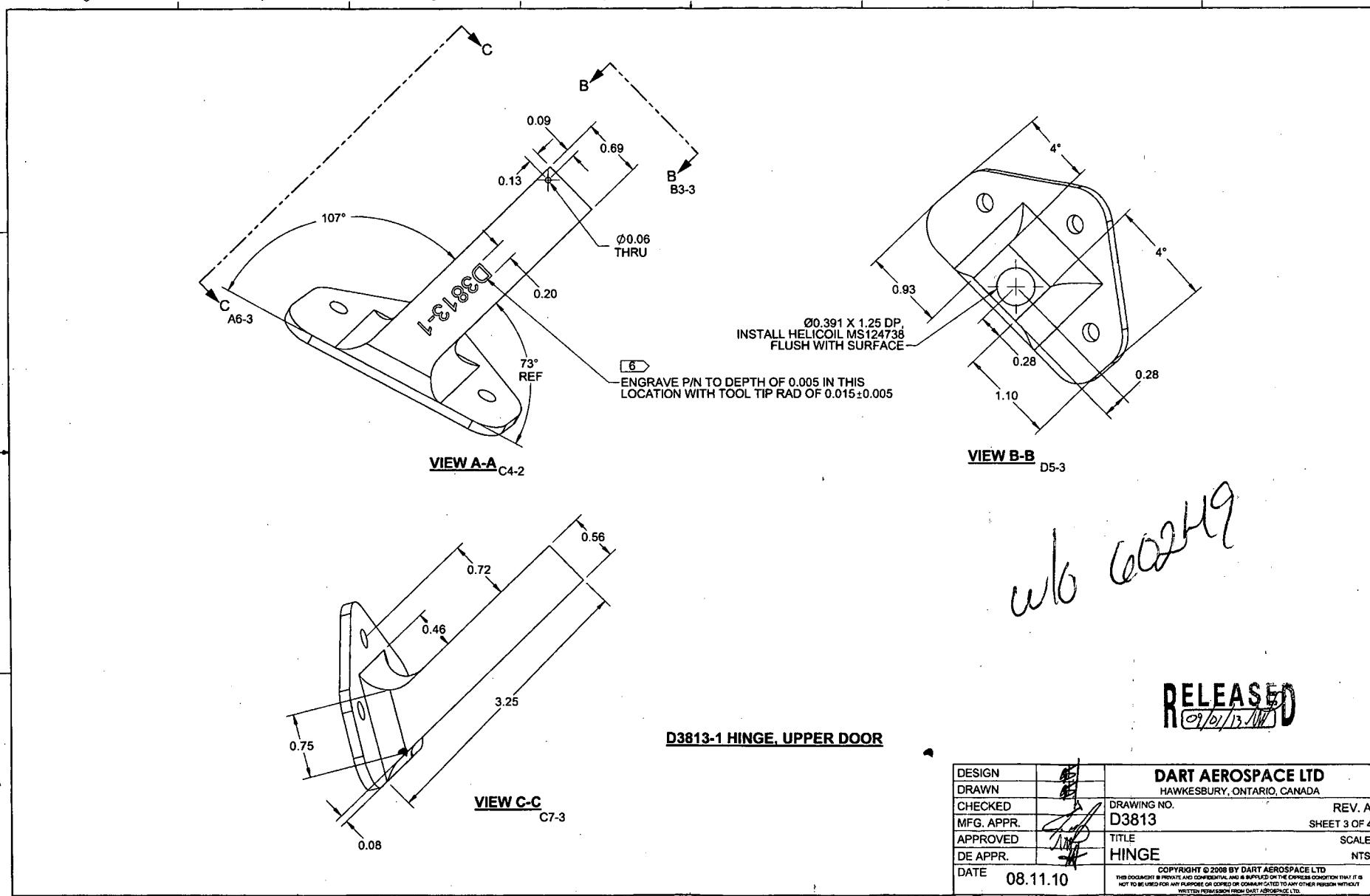
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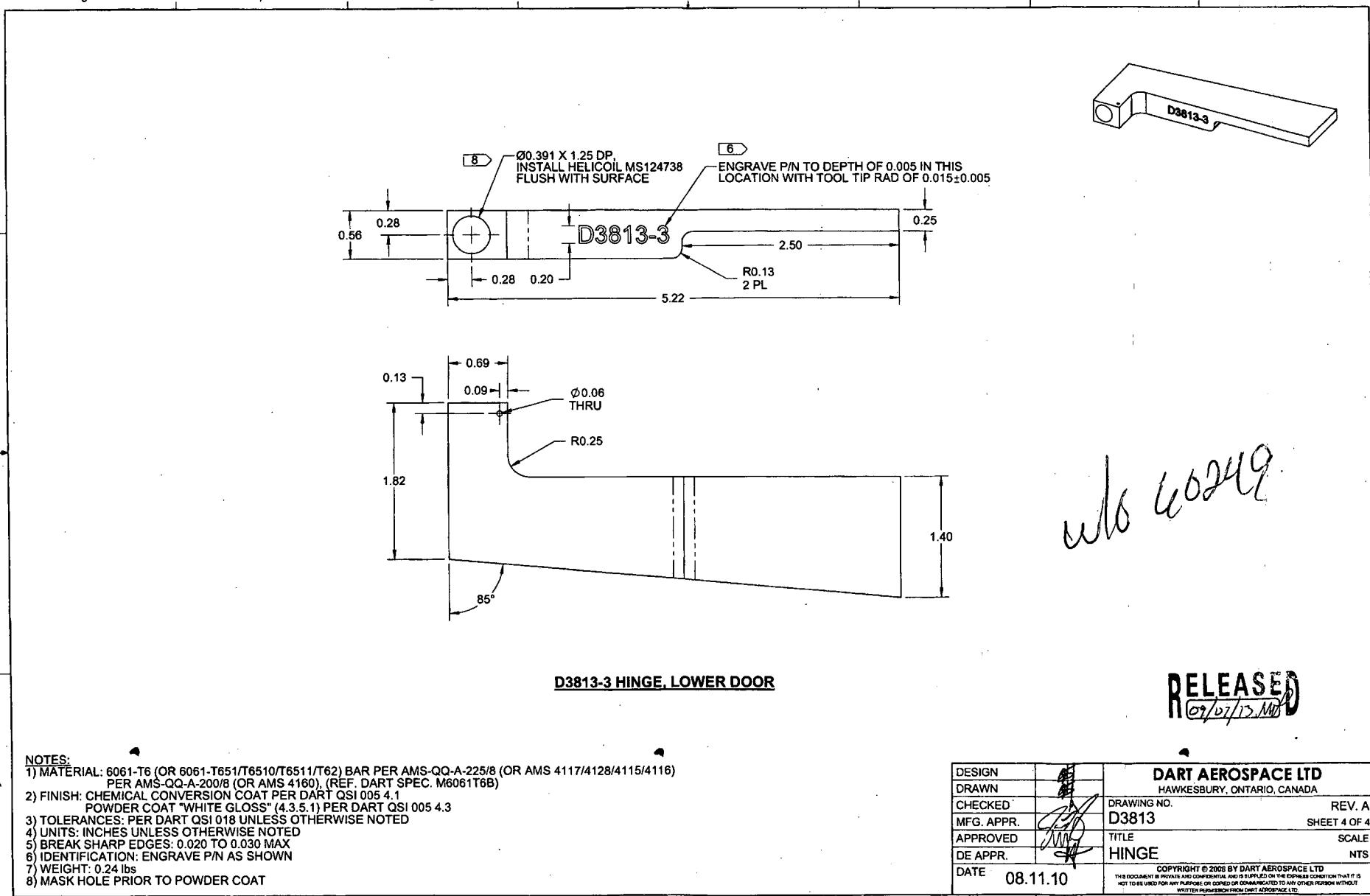


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